

Work Order ID 52265

September 22, 2009 8:26:14 AM



Page 1

Item ID: D3140-95

Revision ID: F

Item Name: Doubler

Start Date: 9/22/09 Start Qty: 4.00

Required Date: 9/25/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: CL
QC:

Accept



Setup Start



Stop



Cust Item ID:



Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100



SHEAR

Shear

Shear

Memo

Cut as per dwg D3140

0.00

0.00

Mr. L oal oal /29

(11X)

110



Small Fab

Small Fab

Small Fab

Memo

1-Scuff surfaces with 80grit sandpaper per QSI 006 2-Deburr. No sharp edges

0.00

0.00

Mr. L oal oal /29

(11X)

(11X) soft surface

120



NC BRAKE

Brake NC

Brake NC

Memo

Bend as per Dwg D3140

0.00

0.00

BB 09/09/30

(11)

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52265

September 22, 2009 8:26:14 AM



Page 2

Item ID: D3140-95

Revision ID: F

Item Name: Doubler

Start Date: 9/22/09 Start Qty: 4.00

Accept



Setup Start



Required Date: 9/25/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

=> Solar 130

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

10/09/10-01

0.00

Q.

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

10/09/10(OC)

0.00

(X) O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52265

September 22, 2009 8:26:14 AM



Page 3

Item ID: D3140-95

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/22/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160

Identify as per dwg & Stock Location: WP

Packaging

Packaging

170



QC

Quality Control

Memo

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

0.00

alio/1 110 SP

09/10/01 JJ

MF 09-10-01

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

0.00

Picklist Print

September 22, 2009 8:26:13 AM

Page 1
1

Work Order ID: 52265



Parent Item: D3140-95RevF



Parent Item Name: Doubler

Start Date: 9/22/09

Required Date: 9/25/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	94.2179	0.6211			X

2024-T3 .032 sheet



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	94.21793158	
102942	1.5	
105555	4.0684	
106272	5.3	
108595	3	
109240	7.02	
110778	23.9106316	
111699	46.4189	
18147	3	

Mark out 29

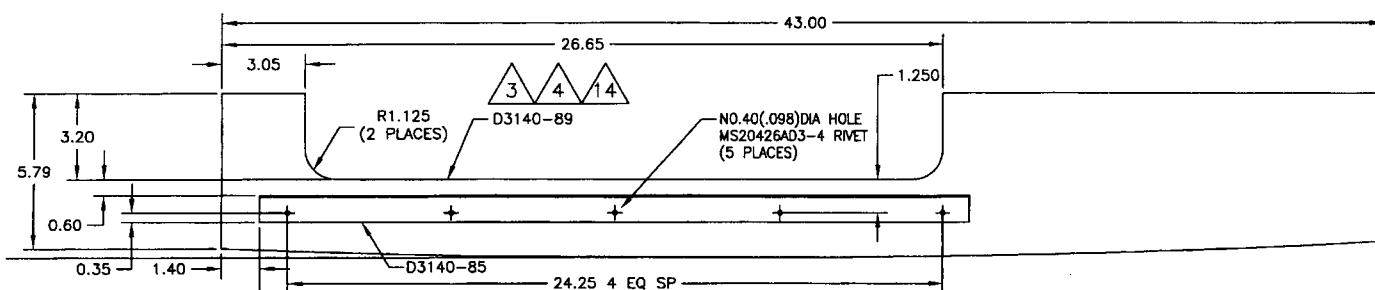
M108595

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

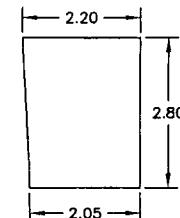
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

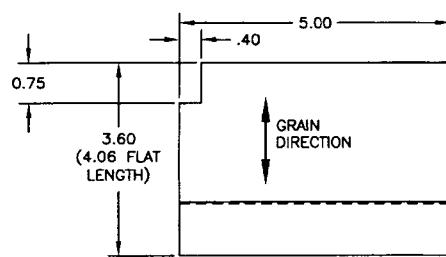
NOTE: Date & initial all entries



D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)

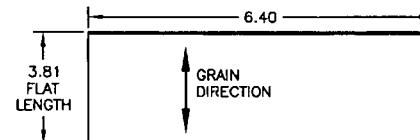
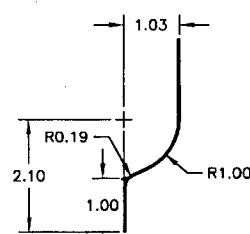


D3140-101 DOUBLER 4 14
 (REPLACES PREMIER P/N B30-23000-101)



D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

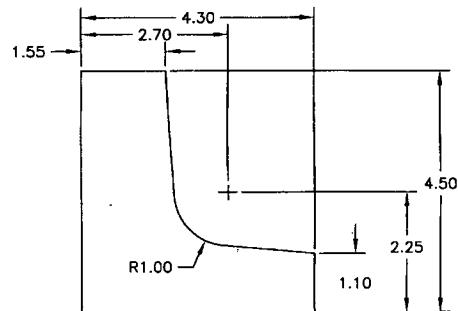
D3140-92 DOUBLER 4 14 F
 (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



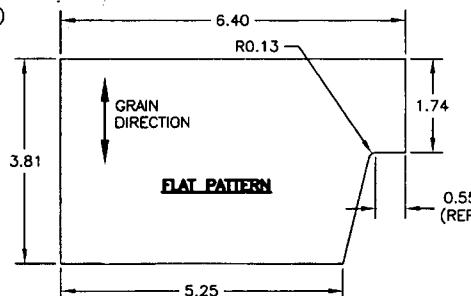
D3140-95 DOUBLER 4 14
 (REPLACES PREMIER P/N B30-23000-95)

RELEASED

52265
d 11/13

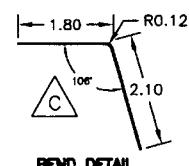


D3140-99 DOUBLER 4 14
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97 FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER 4 14
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



BEND DETAIL

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

DESIGN

4

CB

DART

DART AEROSPACE LTD.
 HAMPSHIRE, ONTARIO, CANADA

DRAWN BY

CB

REV. F

06.10.06

D3140

SHEET 5 OF 7

NTS

CHECKED

JL

APPROVED

H

DRAWING NO.

06.10.06

TITLE

DOOR